

Work Order ID 50198

July 10, 2009 11:24:13 AM



Page 1

Item ID: D2989-043

Accept



Setup Start



Revision ID: D

Stop



Item Name: Basket Lid Assembly

Start Date: 7/16/09 Start Qty: 1.00



Cust Item ID:

Required Date: 7/28/09 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan: *W*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2989

Rev D

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble all ribs in DT9446 jig, weld as per dwg D2989 ☒ 2- tack weld mesh on basket as per dwg D2989 using DT9446 jig ☒ 3- to locate hinges and shims use D2989-041, weld as per dwg D2989 ☐ A/R ER316 S.S. Rod
Batch: *MID 9213*

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

SY 09/04/20 1x

PL0907.21

=> 8 or 10/10/10

(12) P

Work Order ID 50198



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Item ID: D2989-043
Revision ID: D
Item Name: Basket Lid Assembly

Accept



Setup Start



Stop



Start Date: 7/16/09 Start Qty: 1.00



Cust Item ID:

Required Date: 7/28/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel <i>PRESS WASH</i> Memo 1- Plug holes prior to Powdercoat [] 1ST COAT: [] START TIME: <i>11:00</i> [] OVEN TEMPERATURE: <i>400°</i> [] FINISH TIME: <i>11:30</i> [] ***** 2nd coat if necessary ***** [] 2ND COAT: [] START TIME: <i>11:45</i> <i>EL PRESS WASH 08-07-22 TEMP. 400° FINISH 12:15</i>	0.00 0.00 <i>9-7-22</i> 0.00							
140 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							<i>BL 09-07-22 ①</i> <i>CV</i>
150 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<i>09/07/28</i>

W 9.07.28

Picklist Print

July 10, 2009 11:24:12 AM

Work Order ID: 50198

Parent Item: D2989-043RevD

Parent Item Name: Basket Lid Assembly

Comments:

Start Date: 7/16/09

Required Date: 7/28/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2989-17RevD

D2221-1

Manufactured

No

100

Each

0.0000

1.0000



Rib

D2989-3RevD

Manufactured

No

100

Each

3.0000

1.0000



Rib

B48427 1x SY 09/07/20

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

3

48328

1

48506

2

1x SY 09/07/20

D2989-4RevD

Manufactured

No

100

Each

3.0000

1.0000



Rib

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

3

48329

1

48503

2

1x SY 09/07/20

Picklist Print

July 10, 2009 11:24:12 AM

Page 2

Work Order ID: 50198

Parent Item: D2989-043RevD

Parent Item Name: Basket Lid Assembly



Comments:

Start Date: 7/16/09

Required Date: 7/28/09



Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2989-5RevD		Manufactured	No			100	Each	8.0000	2.0000			
												
Rib												



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	8	
48330	4	
48505	4	

2x *SY 09/07/20*

D3182-1RevA		Manufactured	No			100	Each	12.0000	2.0000			
												
Hinge												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	12	
45504	3	
48453	9	

2x *SY 09/07/20*

D3442-3RevA		Manufactured	No			100	Each	10.0000	2.0000			
												
Shim												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	10	
42718	1	
47265	2	
48504	7	

2x *SY 09/07/20*

July 10, 2009 11:24:12 AM

ShopPacket Print

Page 2

Picklist Print

July 10, 2009 11:24:12 AM

Work Order ID: 50198

Parent Item: D2989-043RevD

Parent Item Name: Basket Lid Assembly


Comments:

Start Date: 7/16/09

Required Date: 7/28/09


Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3827-041RevA		Manufactured	No			100	Each	6.0000	1.0000			
												
Rib Assembly (Inboard)												


<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	6	
48454	6	

1x *SY* 09/07/20

D3832-5RevA		Manufactured	No			100	Each	4.0000	1.0000			
												
Mesh (Lid)												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	4	
46307	1	
48216	3	

1x *SY* 09/07/20

D3838-041RevA		Manufactured	No			100	Each	3.0000	1.0000			
												
Rib Assembly (Basket Lid, LH)												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	3	
48333	1	
48502	2	

1x *SY* 09/07/20

Picklist Print

July 10, 2009 11:24:12 AM

Work Order ID: 50198



Parent Item: D2989-043RevD



Parent Item Name: Basket Lid Assembly

Start Date: 7/16/09

Required Date: 7/28/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3838-042RevA		Manufactured	No			100	Each	3.0000	1.0000			
Rib Assembly (Basket Lid, RH)												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

3

48334

1

48501

2

1x *SY* 09/07/20

A3833-5 (qty 2)

Batch: B44767

SY 09/07/21

SY 09/07/21

D2989-043 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

D2989-041 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

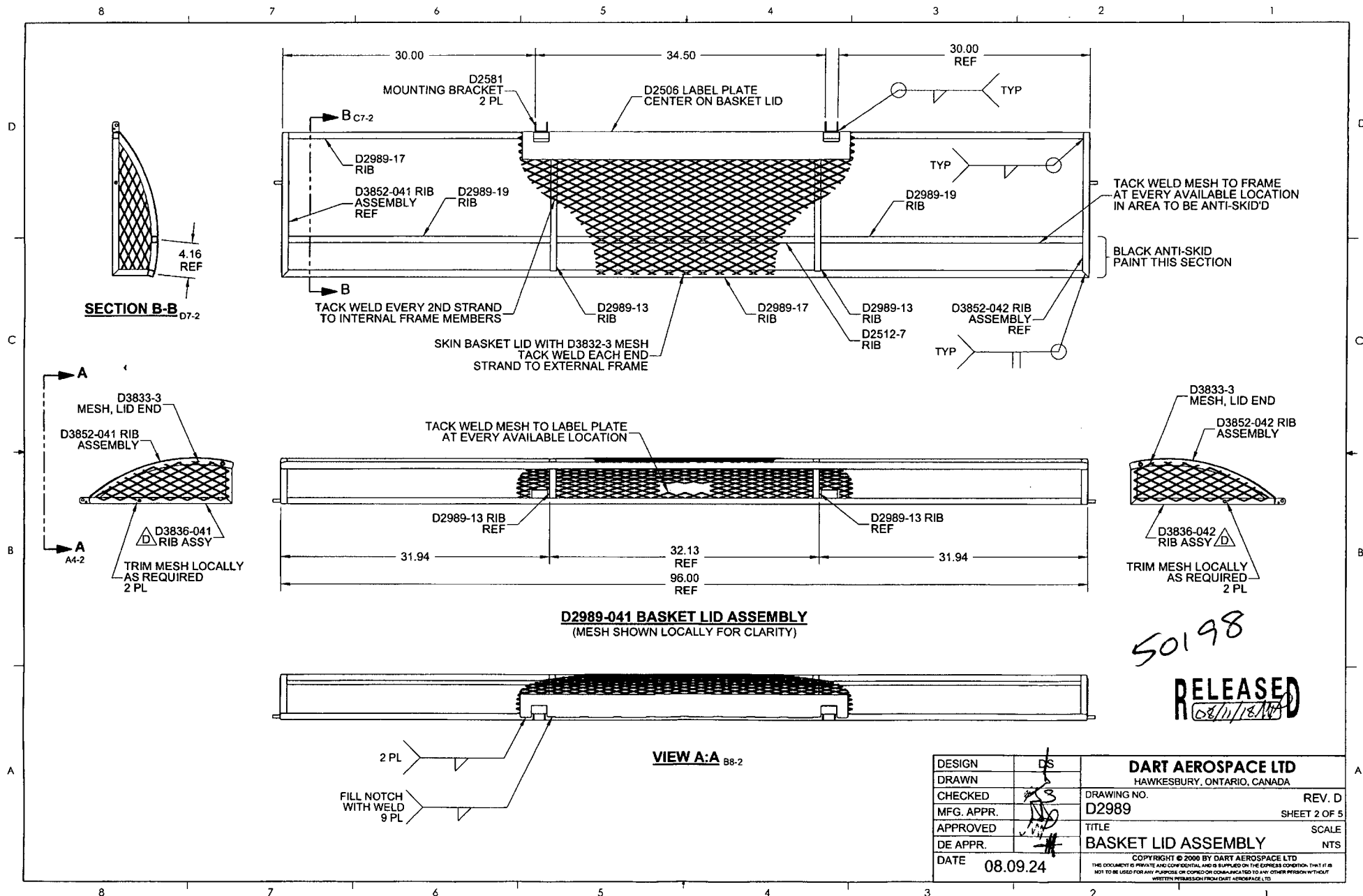
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs
- 8) WELD PER DART QSI 004

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D2989-041	BASKET LID ASSEMBLY
2		X	D2989-043	BASKET LID ASSEMBLY
3	1		D2506	LABEL PLATE
4	1		D2512-7	RIB
5	2		D2581	MOUNTING BRACKET
6		1	D2989-3	RIB
7		1	D2989-4	RIB
8		2	D2989-5	RIB
9	2		D2989-13	RIB
10	2	1	D2989-17	RIB
11	2		D2989-19	RIB
12		2	D3182-1	HINGE
13		2	D3442-3	SHIM
14		1	D3827-041	RIB ASSY (INBOARD)
15	1		D3832-3	MESH, BASKET LID
16		1	D3832-5	MESH, BASKET LID
17	2		D3833-3	MESH, LID END
18		2	D3833-5	MESH, LID END
19	1		D3836-041	RIB ASSY (BASKET LID, LH)
20	1		D3836-042	RIB ASSY (BASKET LID, RH)
21		1	D3838-041	RIB ASSY (BASKET LID, LH)
22		1	D3838-042	RIB ASSY (BASKET LID, RH)
23	1		D3852-041	RIB ASSEMBLY
24	1		D3852-042	RIB ASSEMBLY

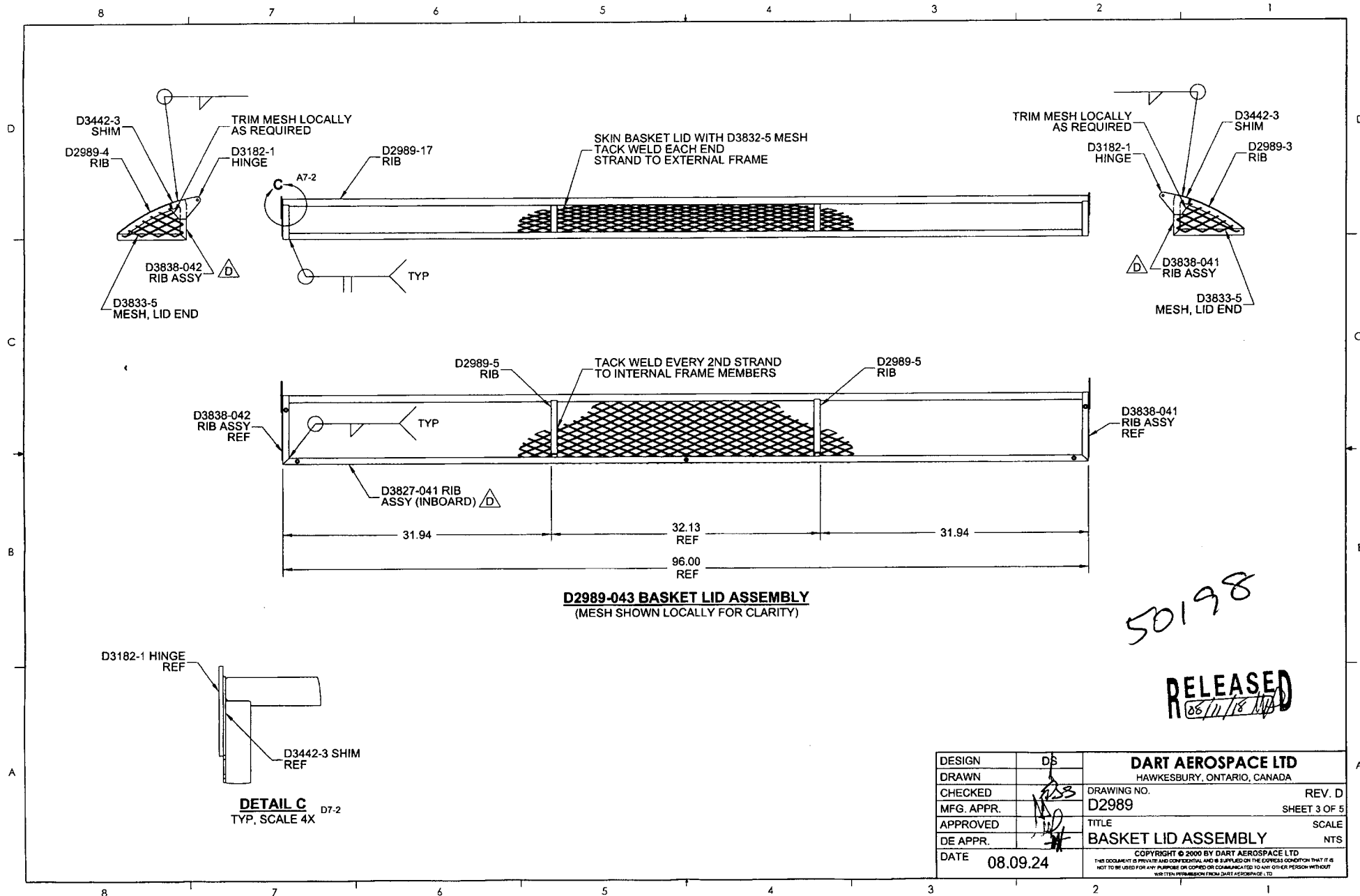
RELEASED
08/11/16

D	REVISED -041/-043 PARTS LISTS AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); D3836-041 REPLACES D2989-9/-15; D3836-042 REPLACES D2989-10/-15; D3838-041 REPLACES D2989-1/-7; D3838-042 REPLACES D2989-2/-7; D3852-041 REPLACES D2989-11; D3852-042 REPLACES D2989-2; REMOVED D327-3 (NOW INSTALLED ON D3836 DWG), D2989-9/-10 (NOW ON D3836 DWG), D2989-1/-2/-7/-15 (NOW ON D3838 DWG) AND D2989-11/-12 (NOW ON D3852 DWG). REASON: TO SATISFY "LEAN MANUFACTURING" PROGRAM	MB	08.09.24
C	FRAME MATERIAL WAS 0.060 WALL; MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT AND CURRENT DRAFTING STANDARD	AJS	08.06.20
B	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	PH	05.06.07
A	NEW ISSUE	DS	00.10.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
DATE	08.09.24	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

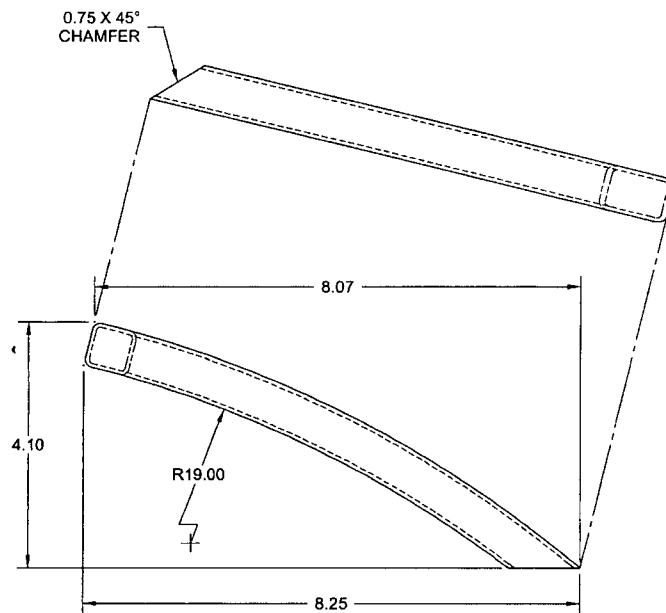


50198

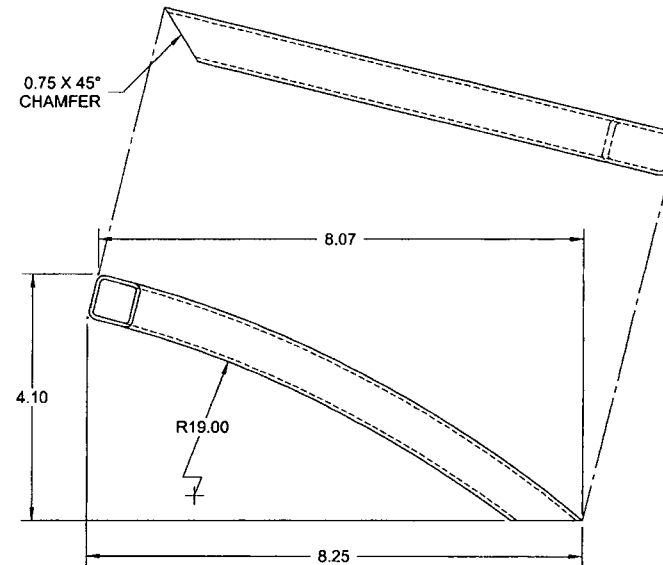
RELEASED
08/11/18/19



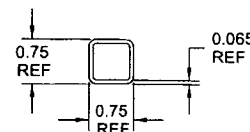
DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	DS	DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
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D2989-3 RIB



D2989-4 RIB



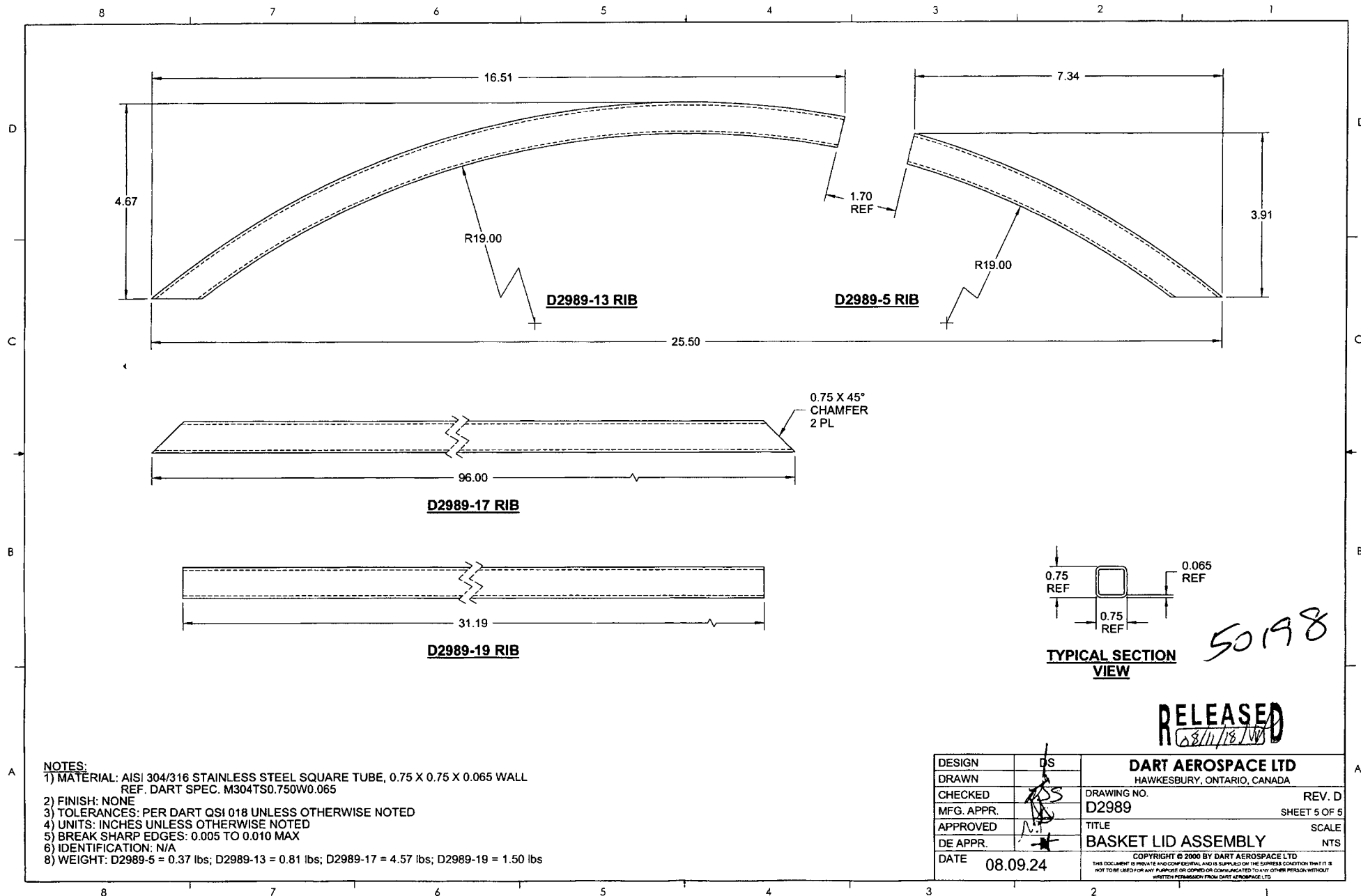
**TYPICAL SECTION
VIEW**

- NOTES:**
- 1) MATERIAL: D3166-3 BASKET HOOP
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 8) WEIGHT: D2989-3/-4 = 0.39 lbs;

DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D2989	REV. D
MFG. APPR.		SHEET 4 OF 5	
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
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50198

RELEASED
08/11/18 MJD



50198
RELEASED
08/11/13

DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	SS	DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 5 OF 5
APPROVED	N.I.	TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
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